

Work Order ID 157613

Tuesday, March 21, 2017 7:45:13 AM

157613

Page 1

Item ID: D2506 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Label Plate
Start Date: 3/21/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 3/24/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: MAR 21 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2506	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.48							
FLOW CNC Waterjet	1-Cut as per Dwg D2506 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
MAR 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.21							
130	NC BRAKE				DAS 30 9-89	5			APR 03 2017
Brake NC	Memo	0.29							
Brake NC	1-Form as per dwg D2506								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					5			DAS 38 9-89 APR 04 2017
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								DAS 6 9-89 APR 04 2017
Packaging	Memo	0.00				5			
Packaging	LOCATION WA004								

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Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

APR 05 2017

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER : _____					

Picklist Print

Tuesday, March 21, 2017 7:45:18 AM

Page 1

Work Order ID: 157613

157613

Parent Item: D2506

D2506

Parent Item Name: Label Plate

Start Date: 3/21/2017

Required Date: 3/24/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08Now laser cutEC
IPP C 06.12.13 ecn 822 ec
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	139.0810	1.22	6.421053			

M304S20GA

304/316 .040 Sheet

ac 17/03/21

Location

Loc Qty

Loc Code

MAT020

138.26

m134495

0.2

m134982

0.1

m135327

2

m135689

1.33

m136327

24.05

m136568

46.58

m137041

64

MAT20

0.821

m133901

0.821

6.5

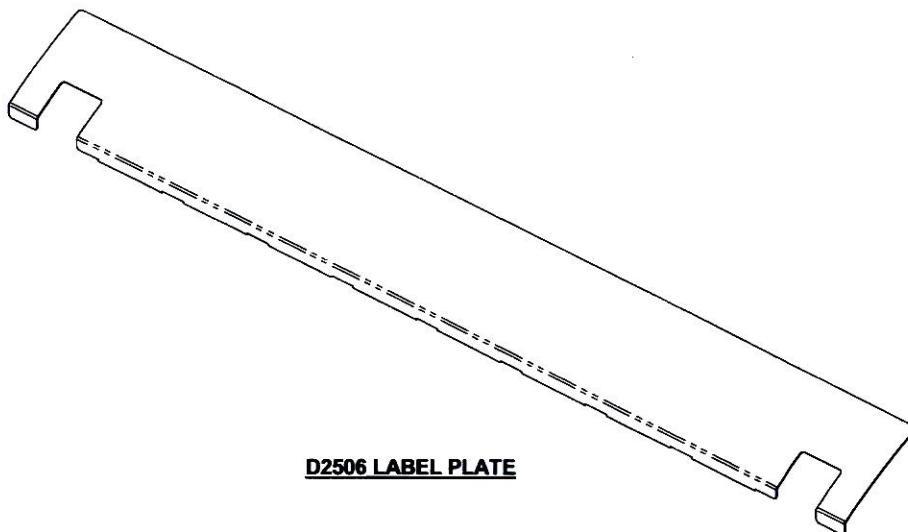
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OTHER : _____					



D2506 LABEL PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157613 MJS
170321

RELEASED
08/11/18 MJS

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
 PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 **F**
 REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" ±1" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2506	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LABEL PLATE	NTS
DATE	08.09.23	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

